

Work Order ID 104428

July-10-13 1:29:39 PM

104428

Page 1

Item ID: D2892-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: SUPPORT

Stop *NS2*

Start Date: 7/10/13 Start Qty: 14.00

14

Cust Item ID:

Required Date: 8/21/13 Req'd Qty: 14.00

14

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 13-07-10 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2892	B

100 0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA082
2-Deburr

JFC 2013-07-19
ET 13-07-20

YTY

110 0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

JFC 2013-07-19
ET 13-07-20

120 0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

14 13-7-22

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Item ID: D2892-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: SUPPORT

Start Date: 7/10/13 Start Qty: 14.00

14

Cust Item ID:

Required Date: 8/21/13 Req'd Qty: 14.00

14

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
HandFXtube	Memo	0.00				14			DAS 05 13-07-23
Hand Finishing Crosstubes	Per note 8 on page 1 of dwg D2892, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24h of cure time								
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00				14			8 13-07-24
Quality Control									
170	Identify as per dwg & Stock Location:	0.00							
170									
Packaging	Memo	0.00							
Packaging									

LG052

(14) 12/13-07-24

~~13/17/21~~

MF 13-7-24 →

Work Order ID 104428

104428

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Item ID: D2892-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: SUPPORT

Start Date: 7/10/13 Start Qty: 14.00

14

Cust Item ID:

Required Date: 8/21/13 Req'd Qty: 14.00

14

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start *NR1*

QC: Date:

SPC (Y/N): Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00


180

QC

Memo

0.00

Quality Control

13/7/24 

Picklist Print

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Work Order ID: 104428

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Parent Item: D2892-1

D2892-1

Parent Item Name: SUPPORT

Start Date: 7/10/13

Required Date: 8/21/13

Start Qty: 14.00

Required Qty: 14.00

Comments:

IPP C02.11.26Added P/O KJ

IPP D 08.03.19 Re-format EC verified by: DD

IPP Rev:E

11.08.04 as per dwg rev.B DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK077		Manufactured	No			110	Each	7.0000	0.5	7			

DSK077

D2892-1 TURNING DETAIL

**

17-07-20

Location

Loc Qty

Loc Code

MAT060

7

101398

7

x7

DART AEROSPACE LTD		Work Order:	104428
Description: Ø2.500 Support		Part Number:	D2892-1
Inspection Dwg: D2892	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.115	0.150		0.134	0.134	0.136	0.135	0.135
AB	0.290	0.310		0.300	0.300	0.300	0.300	0.300
AC	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AD	0.115	0.150		0.125	0.124	0.125	0.126	0.126
AE	0.240	0.260		0.249	0.249	0.248	0.248	0.249
AF	0.188	0.193		0.190	0.190	0.190	0.190	0.190
AG	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AH	1.116	1.156		1.142	1.139	1.139	1.143	1.143
AI	0.454	0.474		0.4615	0.463	0.462	0.460	0.462
AJ	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AK	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AL	0.257	0.262		0.259	0.259	0.259	0.259	0.259
AM	1.663	1.683		1.677	1.676	1.678	1.678	1.678
AN	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AO	0.022	0.042		0.032	0.032	0.032	0.032	0.032
AP	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: JFC/	Date: 2013-07-19
Audited by: SL	Date: 13-7-20
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.01.31	Dwg Rev updated	KJ	
D	13.05.22	Dimensions updated	KJ	

DART AEROSPACE LTD		Work Order:	104428
Description: Ø2.500 Support		Part Number:	D2892-1
Inspection Dwg: D2892	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	7x8	8x8	9x8	10x8
HAAS Section								
AA	0.115	0.150		.136	.135	.134	.135	.130
AB	0.290	0.310		0.300	0.300	0.300	.300	.300
AC	0.040	0.060		0.050	0.050	0.050	.050	.050
AD	0.115	0.150		.125	.126	.125	.129	.131
AE	0.240	0.260		0.249	0.249	0.249	.249	.249
AF	0.188	0.193		0.190	0.190	0.190	.190	.190
AG	0.240	0.260		0.250	0.250	0.250	.250	.250
AH	1.116	1.156		1.138	1.144	1.144	1.144	1.144
AI	0.454	0.474		.468	.456	.459	.458	.458
AJ	0.240	0.260		0.250	0.250	0.250	.250	.250
AK	0.053	0.073		0.063	0.063	0.063	.063	.063
AL	0.257	0.262		0.259	0.259	0.259	.259	.259
AM	1.663	1.683		1.678	1.678	1.678	1.678	1.679
AN	0.053	0.073		0.063	0.063	0.063	.063	.063
AO	0.022	0.042		0.032	0.032	0.032	.032	.032
AP	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AQ								
AR								
AS								
AT								
Accept/Reject								



Measured by: JFC / 41	Date: 2013-07-19
Audited by: JX	Date: 13-7-22
Preliminary Approval:	Date:



Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
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D	13.05.22	Dimensions updated	KJ	

DART AEROSPACE LTD		Work Order:	104428
Description: Ø2.500 Support		Part Number:	D2892-1
Inspection Dwg: D2892	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1 1	1 2	1 3	1 4	5
HAAS Section								
AA	0.115	0.150		.128	.133	.134	.134	/
AB	0.290	0.310		.300	.300	.300	.300	
AC	0.040	0.060		.050	.050	.050	.050	
AD	0.115	0.150		.132	.126	.125	.125	
AE	0.240	0.260		.249	.249	.249	.249	
AF	0.188	0.193		.190	.190	.190	.190	
AG	0.240	0.260		.250	.250	.250	.250	
AH	1.116	1.156		1.144	1.144	1.143	1.142	
AI	0.454	0.474		.455	.458	.456	.457	
AJ	0.240	0.260		.250	.250	.250	.250	
AK	0.053	0.073		.063	.063	.063	.063	
AL	0.257	0.262		.259	.259	.259	.259	
AM	1.663	1.683		1.678	1.679	1.676	1.678	
AN	0.053	0.073		.063	.063	.063	.063	
AO	0.022	0.042		.032	.032	.032	.032	
AP	2.779	2.789		2.789	2.789	2.789	2.789	
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by:		Date:	13-07-20
Audited by:		Date:	10-7-22
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
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C	12.01.31	Dwg Rev updated	KJ	
D	13.05.22	Dimensions updated	KJ 	

NOTES:

1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRc)
(REF DART SPEC. D6104)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 (REF. X.XXX = ±0.010) UNLESS OTHERWISE NOTED

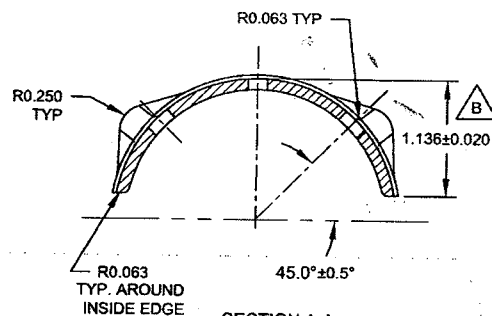
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

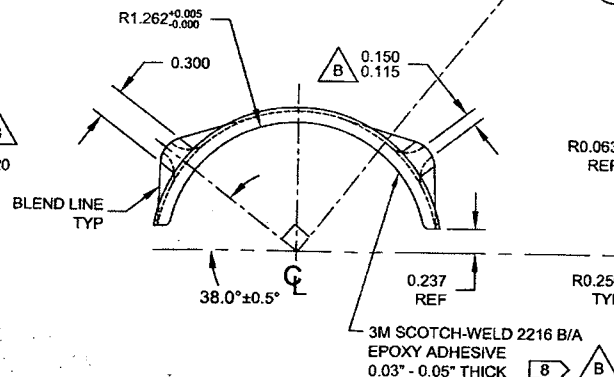
6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING
0.010-0.020 DEEP, PER DART QSI 044 6.3.

7) WEIGHT: 0.41 lb

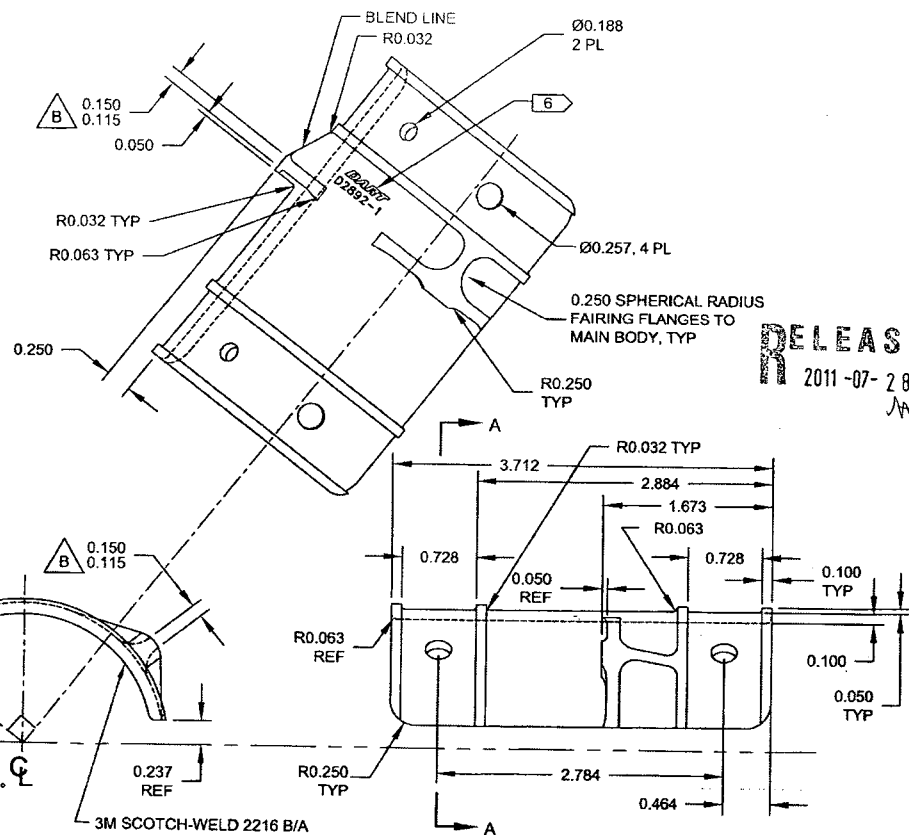
8) FOR THE ENTIRE INNER CONCAVE SURFACE:
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.



SECTION A-A



D2892-1 SUPPORT



RELEASED
2011-07-28

B	RMV FINISH, ADD 3M 2216, ADD H925 MAT'L OPTION, UPDATE TOLERANCE (ZN D5-1.85-1.86-1)	CP	11.07.15
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	92		
DRAWN	92		
CHECKED	ASS		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.07.15		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2892 TITLE Ø2.500 SUPPORT SCALE NTS REV. B SHEET 1 OF 1 COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

104428 NLS
1307-10